

Date: Thursday, 12/13/2007 2:39:01 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PLUG
Job Number : 36327	
Estimate Number : 10178	
P.O. Number : <i>N/A</i>	Part Number : D25941
This Issue : 12/13/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2594 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i>	Drawing Revision : C
Previous Run : 35919	Material : <i>N/A</i>
Type : MACHINED PARTS	Due Date : 1/24/2008
Written By : <i>HA</i>	Qty: 500 Um: Each
Checked & Approved By : <i>HA 07.12.13</i>	
Comment : Est D 02.08.22 Make in Cobra KJ	
est E 06.12.11 ecn 836 EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0625	6061-T6 Round Bar .625"
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Comment: Qty.: 0.0547 f(s)/Unit Total : 27.3525 f(s)  
 Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8)  
 1100-0 (QQ-A-225/1) Ø0.625" Rod  
 (M5052H32R0.625) or (M6061T6R0.625). Batch *M106104* *H.A 07/12/19*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL  
 1-Make as per Dwg D2594-1 and Folio FA262.  
 2-Break all sharp edges 0.010 max.

*H.A / ml 07/12/19*  
*RP 07/12/21*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*RP 07/12/21*

*H.A / ml*

*07/12/19*

*598*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*56 07.12.22*

*548*

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
 Acid etch and alodine as per QSI 005 4.1

*BR 08-01-04*

*542*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/01/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/13/2007 2:39:01 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 36327

Part Number: D25941

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



*M 106379*



*(542)*

Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)

*BR 0801-07.*

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*M-1 08/01/08*  
~~*M 106379*~~



*(542X)*

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

~~*BR 0801-07.*~~

8.0

PACKAGING 1

PACKAGING RESOURCE #1



*(542X)*

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *F.P-I*

*M-1 08/01/08*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



*(542)*

Comment: FINAL INSPECTION/W/O RELEASE

*08/01/08*

Job Completion



*2008.1.18*

*h*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	36327
<b>Description:</b> Plug		<b>Part Number:</b>	D2594-1
<b>Inspection Dwg:</b> D2594 <b>Rev:</b> C		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.060	+/-0.005	0.060	✓			
0.500	+/-0.010	0.500	✓			
0.625	+/-0.010	0.622	✓			
0.430	+0.000/-0.002	0.4293	✓			
0.090	+0.000/-0.002	0.0885	✓			
0.045	+0.000/-0.002	0.045	✓			

<b>Measured by:</b> H.A/Pmk	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/12/19	<b>Date:</b> 07/12/19	<b>Date:</b>	

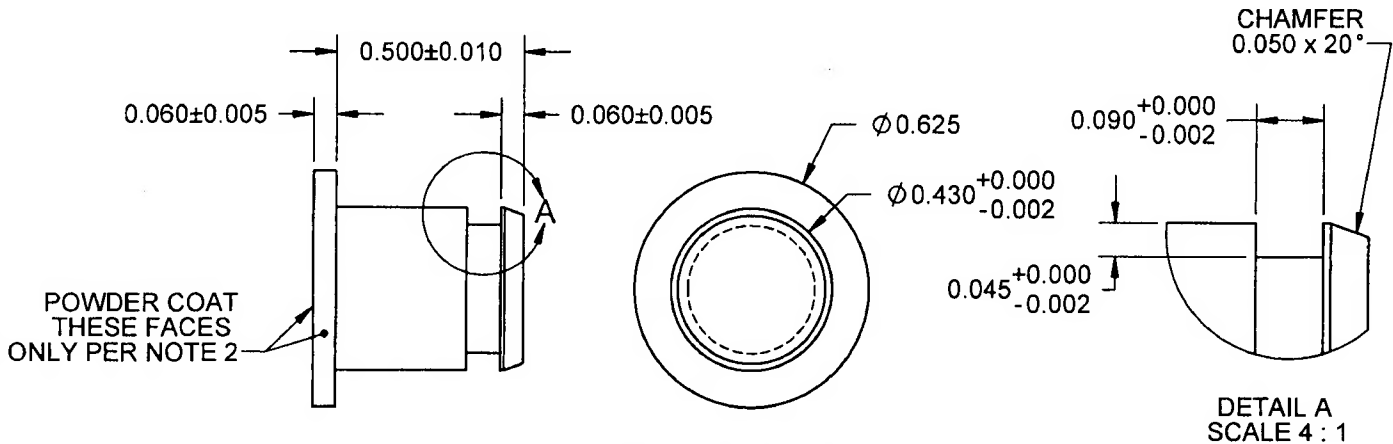
Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF	
B	06.12.20	Dwg Rev. updated	KJ/JLM [Signature]	[Signature]

**DART**

DESIGN #	DRAWN BY CB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. <b>D2594</b>	REV. C SHEET 1 OF 1
DATE <b>06.11.20</b>	TITLE <b>PLUG</b>		SCALE 2:1
REV	DATE	DESCRIPTION	
A	96.09.16	NEW ISSUE	
B	97.03.15	ADD GROOVE AND O-RING	
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE	

RELEASED

06.11.28

**D2594-1 PLUG****D2594-1 PLUG NOTES:**

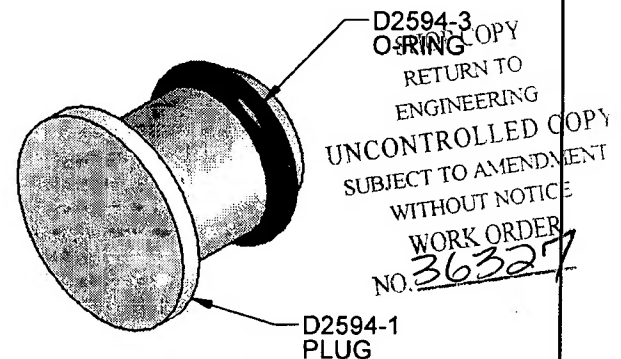
- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3  $\triangle C$
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

**D2594-3 O-RING NOTES:**

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011  $\triangle C$

**PARTS LIST:**

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING

**D2594 PLUG ASSEMBLY**

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